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(54) **METHOD OF MAKING PREFASTENED
REFASTENABLE DISPOSABLE ABSORBENT
ARTICLES**

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(Continued)

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(58) **Field of Classification Search**
None
See application file for complete search history.

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(57) **ABSTRACT**

The present disclosure relates to methods for manufacturing absorbent articles, and in particular, methods for making pre-fastened refastenable pant diapers. Aspects of the methods according to the present disclosure relate to the fabrication of refastenable pant diapers wherein discrete chassis are advanced in a machine direction such that the lateral axis is parallel with the machine direction. First side panels are then refastenably connected with the first waist region, and second side panels are permanently connected the second waist regions of the discrete chassis. The chassis are connected with discrete lengths of side panel material and/or connection zone material. The chassis are then folded, and the first and second side panels are subsequently bonded together. The article is then subjected to knife cut at or adjacent the bonded regions to create discrete, pre-fastened refastenable pant diapers.

Related U.S. Application Data

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(51) **Int. Cl.**

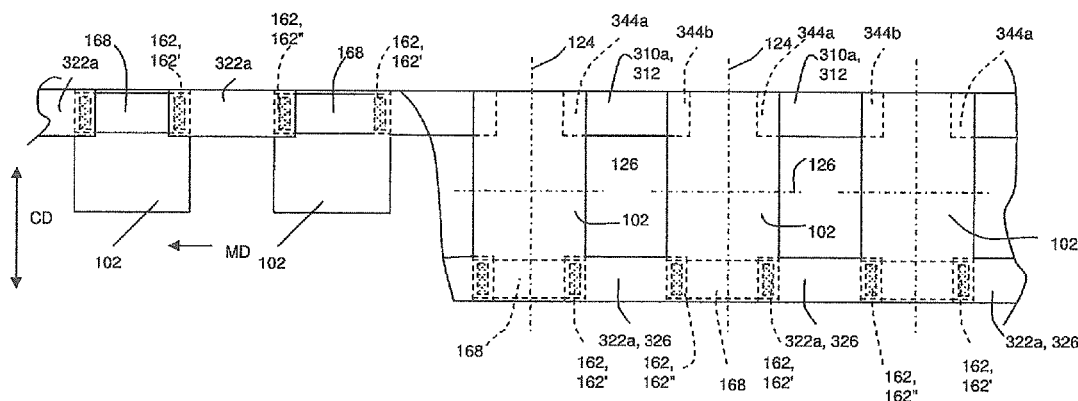
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8 Claims, 8 Drawing Sheets



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156/1084 (2015.01)

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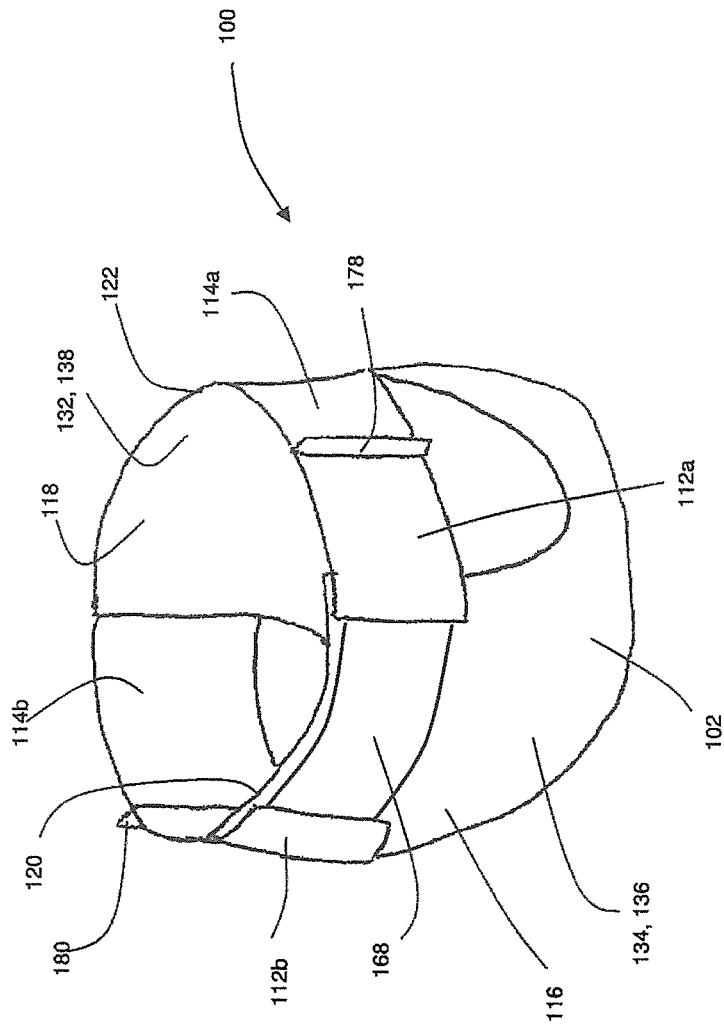


Figure 1

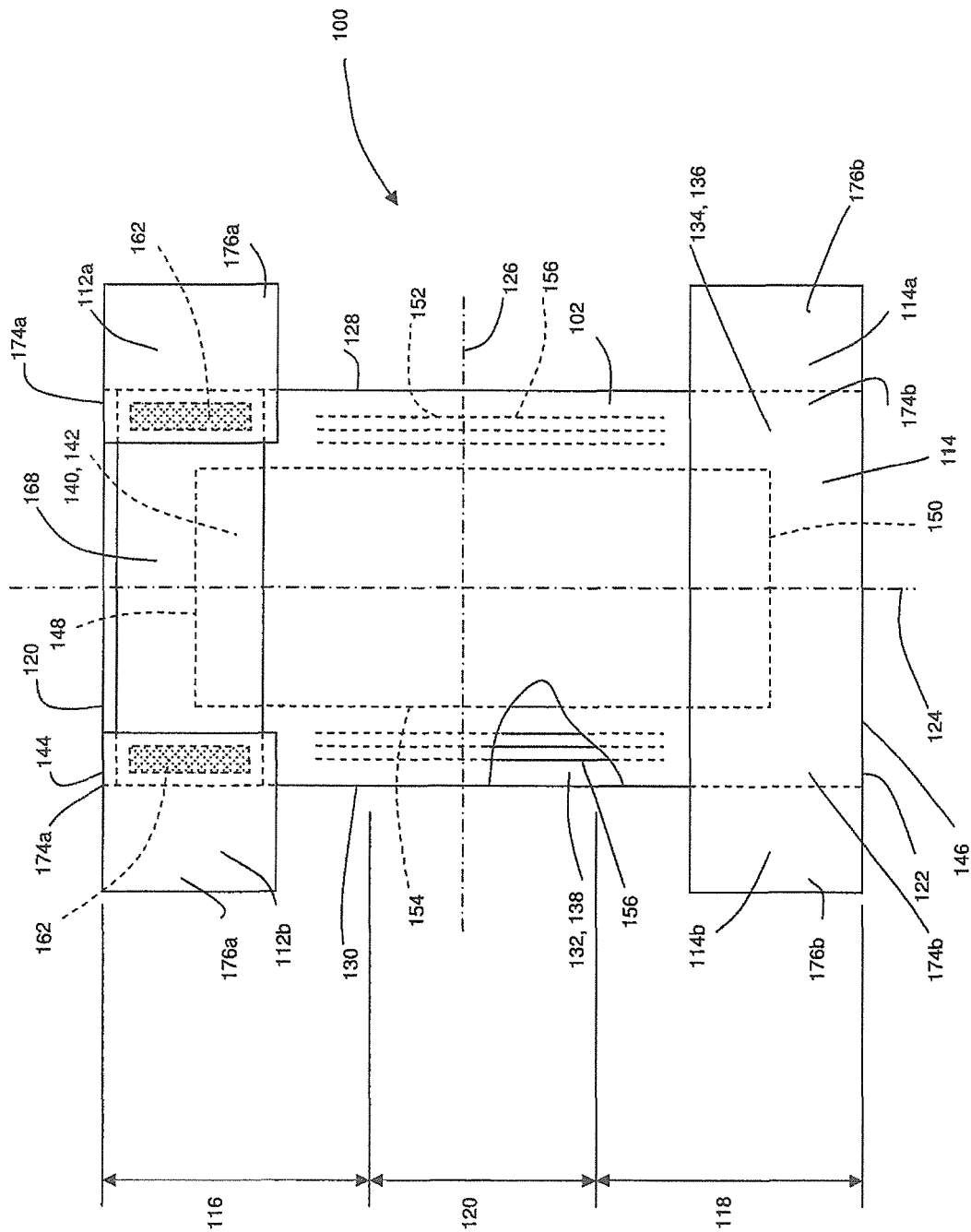


Figure 2A

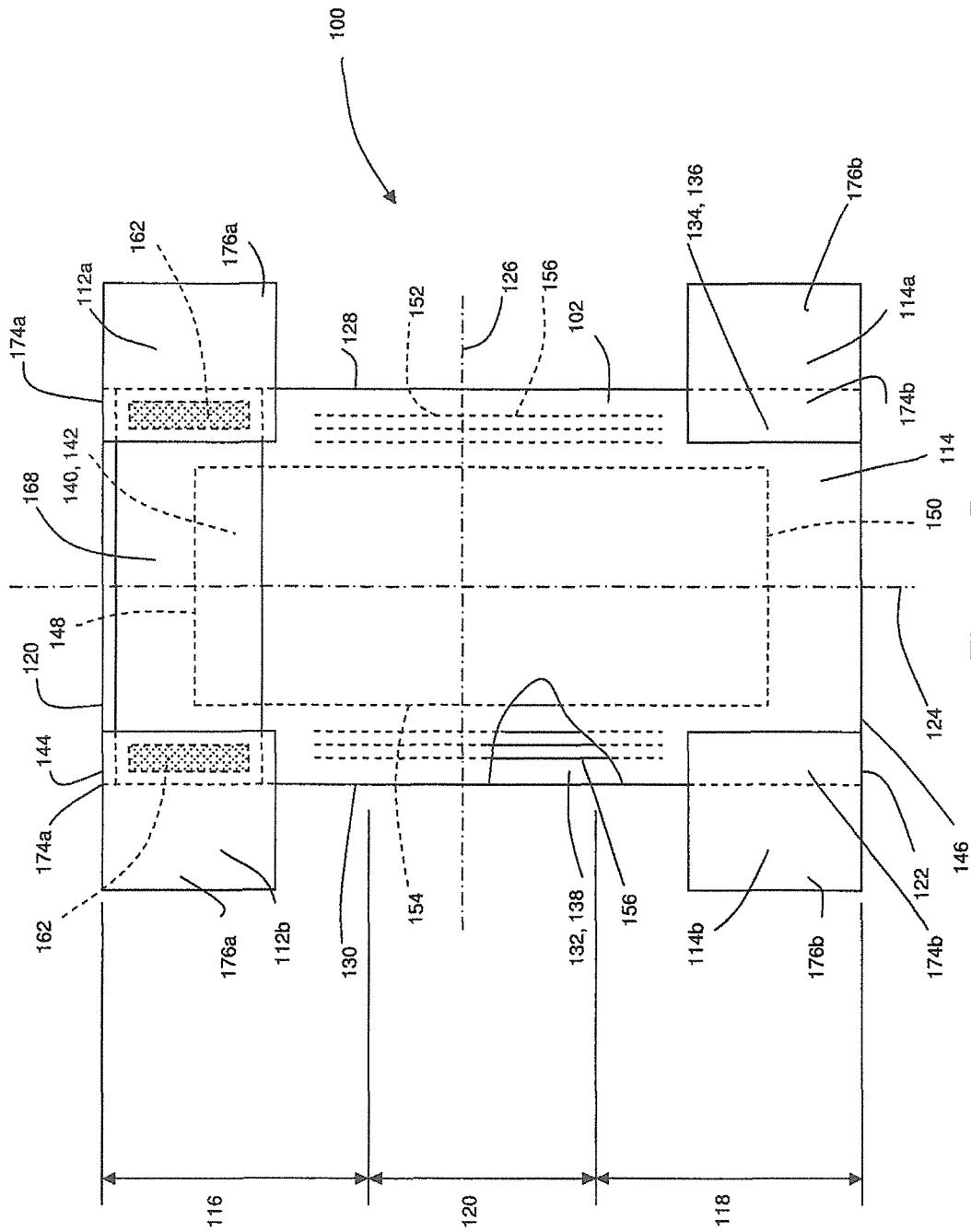


Figure 2B

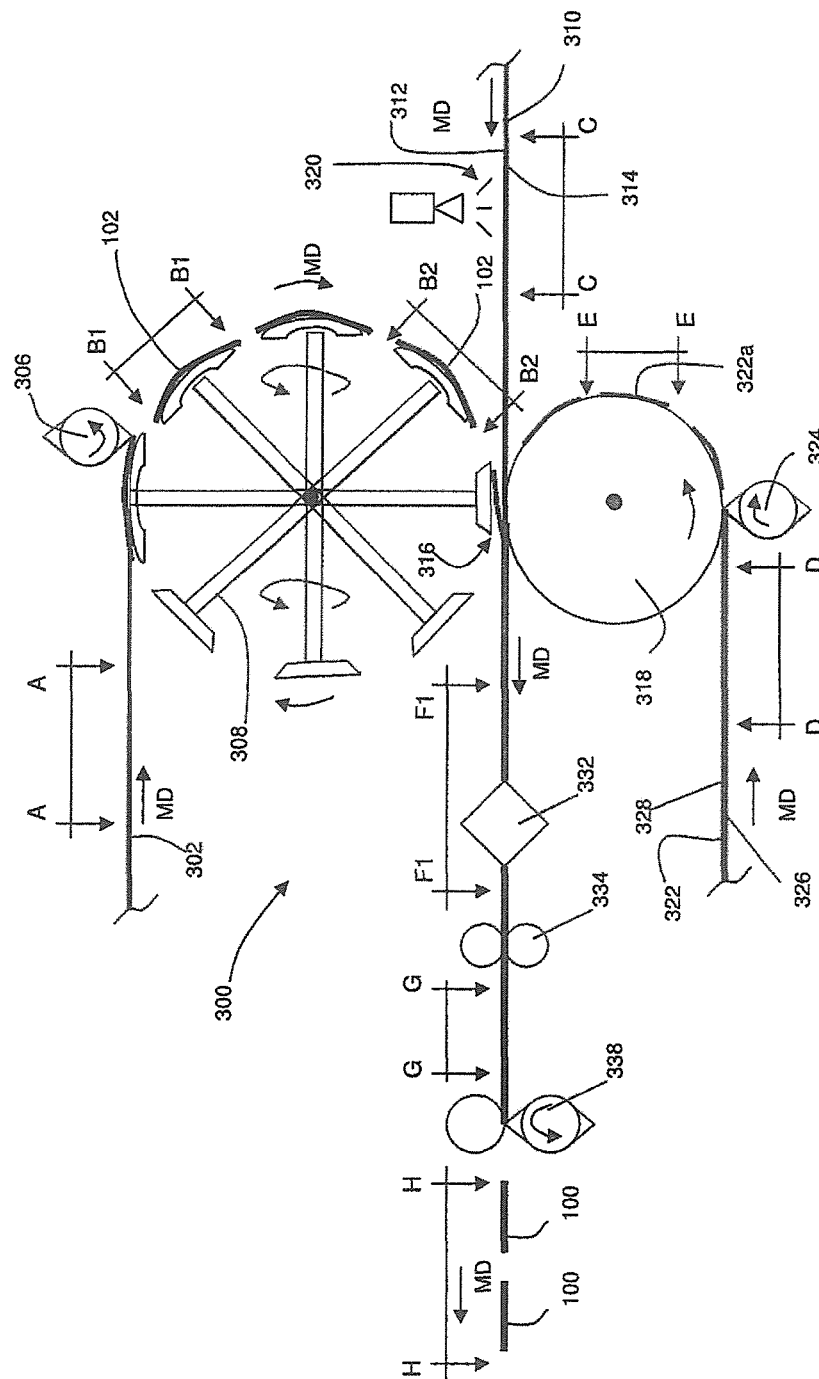


Figure 3

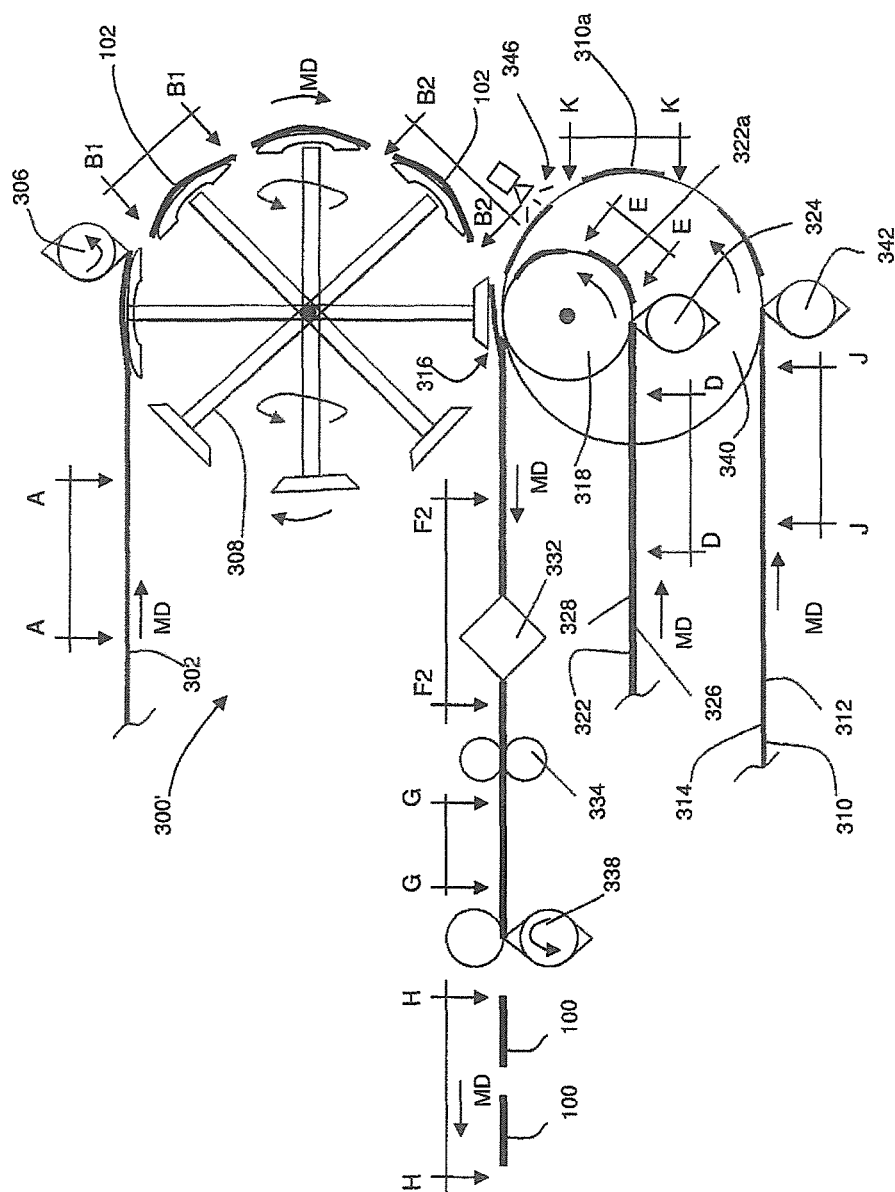


Figure 4

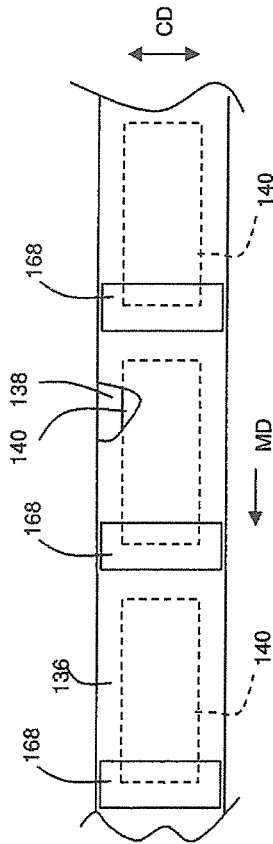


Figure 5A

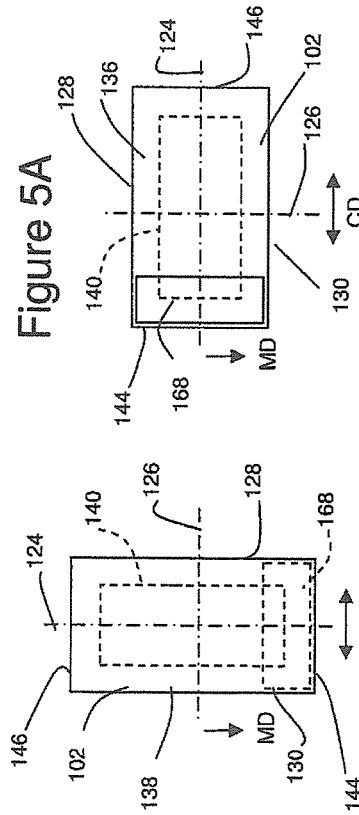


Figure 5B1

Figure 5B2

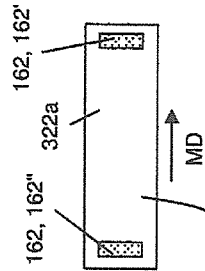


Figure 5E

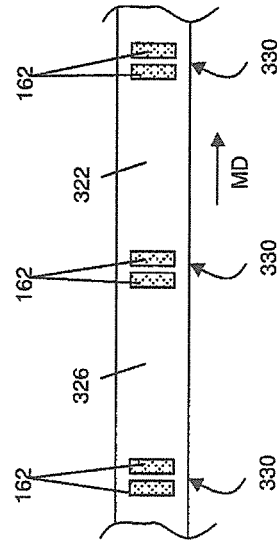


Figure 5D

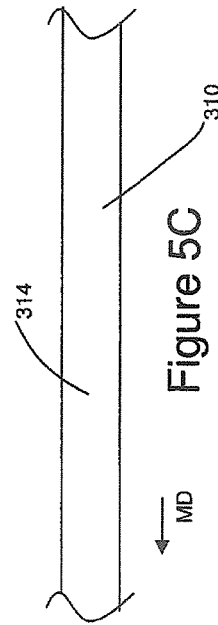


Figure 5C

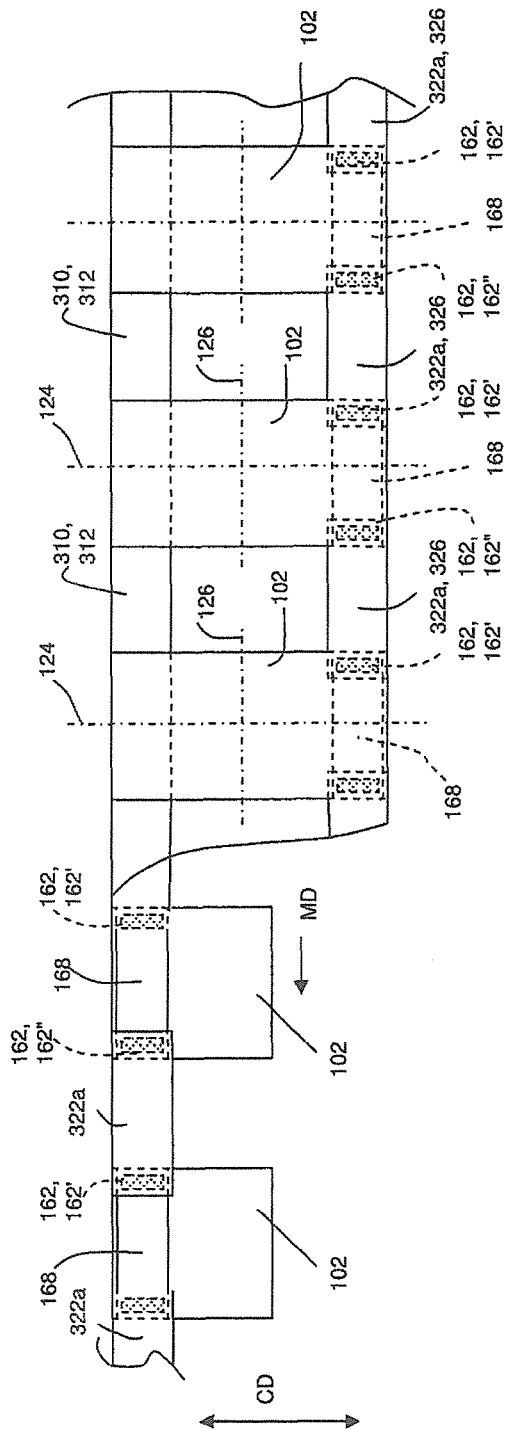


Figure 5F1

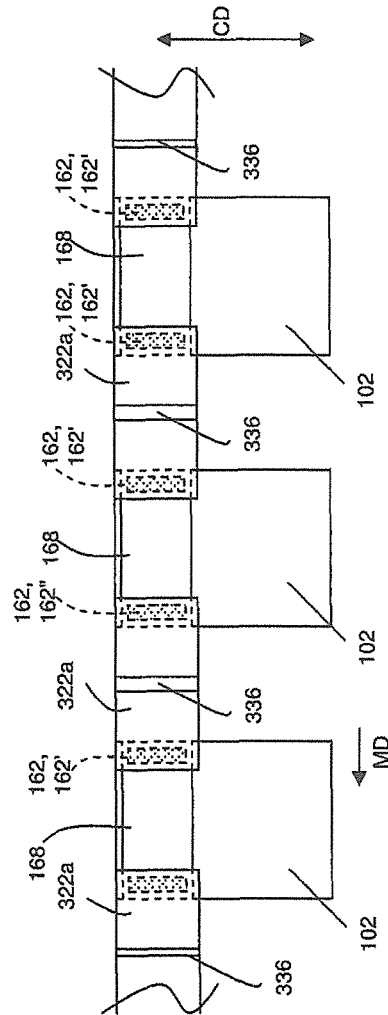


Figure 5G

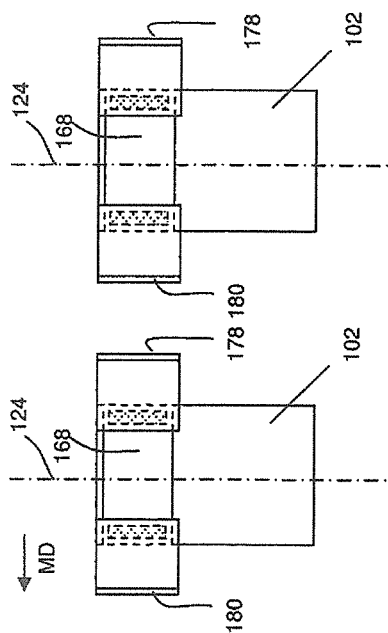


Figure 5H

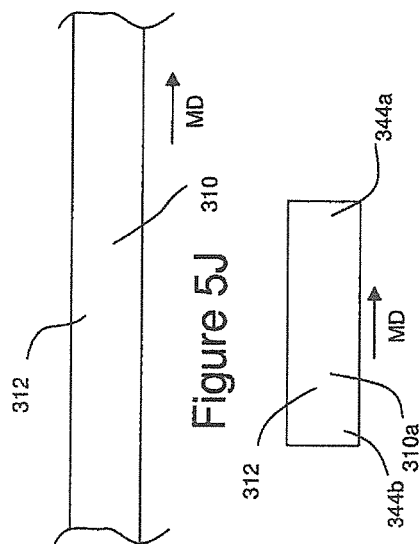


Figure 5J

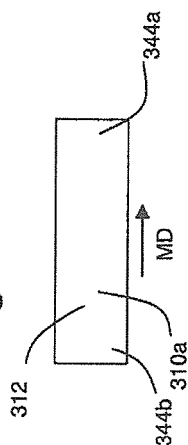


Figure 5K

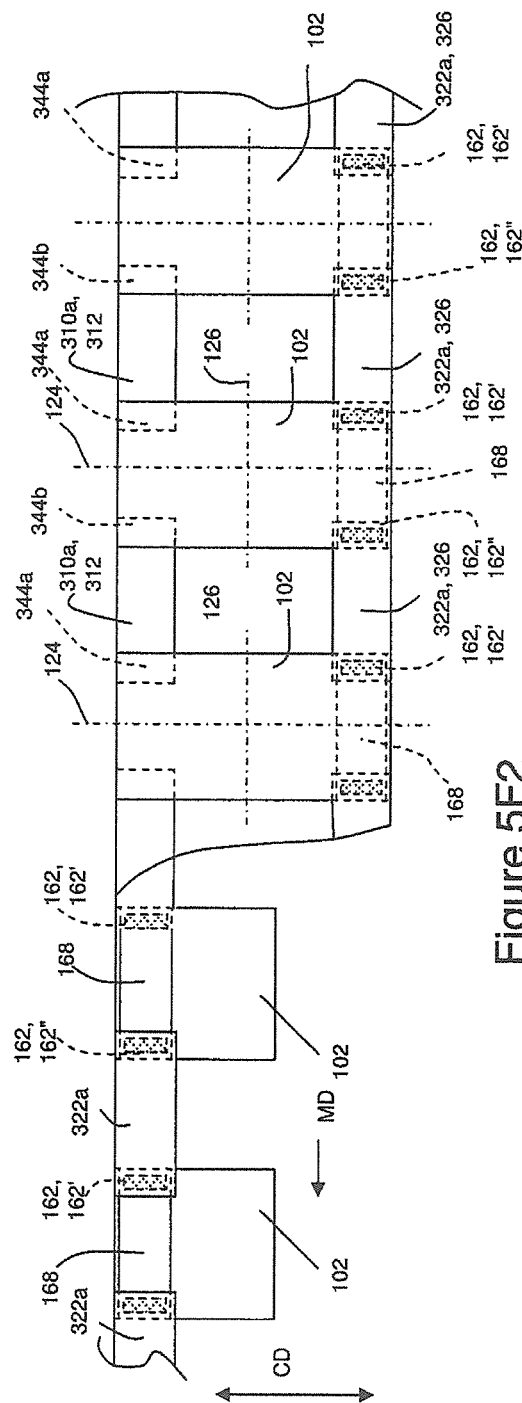


Figure 5F2

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METHOD OF MAKING PREFASTENED REFASTENABLE DISPOSABLE ABSORBENT ARTICLES

CROSS REFERENCE TO RELATED APPLICATION

This application is a divisional of application Ser. No. 13/221,127, filed on Aug. 30, 2011 now U.S. Pat. No. 8,945,326, which claims the benefit of U.S. Provisional Application No. 61/382,590, filed on Sep. 14, 2010, which are all incorporated herein by reference.

FIELD OF THE INVENTION

The present disclosure relates to methods for manufacturing absorbent articles, and more particularly, to methods for making pre-fastened refastenable disposable absorbent articles.

BACKGROUND OF THE INVENTION

Along an assembly line, various types of articles, such as for example, diapers and other absorbent articles, may be assembled by adding components to and/or otherwise modifying an advancing, continuous web of material. For example, in some processes, advancing webs of material are combined with other advancing webs of material. In other examples, individual components created from advancing webs of material are combined with advancing webs of material, which in turn, are then combined with other advancing webs of material. In some cases, individual components created from advancing web or webs are combined with other individual components created from other advancing web or webs. Webs of material and component parts used to manufacture diapers may include: backsheet, topsheets, leg cuffs, waist caps, absorbent core components, front and/or back ears, fastening components, and various types of elastic webs and components such as leg elastics, barrier leg cuff elastics, stretch side panels, and waist elastics. Once the desired component parts are assembled, the advancing web(s) and component parts are subjected to a final knife cut to separate the web(s) into discrete diapers or other absorbent articles.

In some converting configurations, discrete chassis spaced apart from each other are advanced in a machine direction and are arranged with a longitudinal axis parallel with the cross direction. Opposing waist regions of discrete chasses are then connected with continuous lengths of elastically extendable front and back belts advancing in the machine direction. While connected with the chassis, the front and back belts are maintained in a fully stretched condition along the machine direction. As such, the positions of the advancing chassis and associated belts can be controlled more easily to allow for more accurate registration and phasing of subsequent converting operations, such as folding, seaming, and cutting. However, introducing discrete elastically extendable components in one or both of the waist regions presents a different challenge with regard to maintaining control and positioning of the advancing discrete elastically extendable components relative to other components, such as an article chassis, can be difficult. For example, when manufacturing refastenable diaper pants with a chassis connected with discrete lengths of elastically extendable panel material disposed in one or both waist regions, some processes utilize a sheet that interconnects the discrete lengths of extendable panel material together during manufacturing, and in turn, enhances the ability to control the advancing components. The sheet is

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included as part of the manufactured diapers and must be removed by the user before using the refastenable features of the diapers. However, including such a removable sheet on manufactured diaper pants may have a negative impact on costs and aesthetics.

SUMMARY OF THE INVENTION

The present disclosure relates to methods for manufacturing absorbent articles, and in particular, methods for making pre-fastened refastenable pant diapers. Aspects of the methods according to the present disclosure relate to the fabrication of refastenable pant diapers wherein discrete chassis are advanced in a machine direction such that the lateral axis is parallel with the machine direction. First side panels are then refastenably connected with the first waist region, and second side panels are permanently connected the second waist regions of the discrete chassis. The chassis are connected with discrete lengths of side panel material and/or connection zone material, forming a continuous web of articles formed by intermittently spaced chassis and intermittently spaced side panels bridging the gap between the intermittently spaced chassis. The chassis are then folded, and the first and second side panels are subsequently bonded together. The article is then subjected to knife cut at or adjacent the bonded regions to create discrete, pre-fastened refastenable pant diapers.

In one form, a process may be adapted for assembling disposable pre-fastened pant diapers, each pant diaper comprising a chassis having a first waist region longitudinally opposed to a second waist region, and having a longitudinal axis and a lateral axis, the chassis comprising: a topsheet, a backsheet, and an absorbent core disposed between the topsheet and the backsheet, each pant diaper further comprising laterally opposed first side panels refastenably connected with the first waist region; and laterally opposed second side panels permanently connected with the second waist region and permanently connected with corresponding first side panels to form a waist opening. The process includes the steps of: advancing a first continuous web having a first surface and an opposing second surface in a machine direction wherein fastener components are connected with the first surface; cutting the first continuous web into discrete patches, each patch having a leading end region, a trailing end region, and a central region disposed between the leading and trailing end regions, wherein a first fastener is located in the leading end region and a second fastener is located in the trailing end region; advancing a second continuous web in the machine direction; advancing a third continuous web in the machine direction; cutting the third continuous web into discrete chassis, wherein each chassis advances such that the longitudinal axis is parallel with the machine direction; turning each chassis such that the lateral axis is parallel with the machine direction; refastenably connecting the first waist region of each chassis with a trailing end region of a first advancing patch and with a leading end region of a second advancing patch; permanently connecting the second waist region of each chassis with the second continuous web; folding each chassis along the lateral axis to position the central region of each patch into a facing relationship with the second continuous web; bonding a portion of the central region each patch with the second continuous web to create discrete bond regions; and cutting the second continuous web and the patches along the bond regions to create discrete pre-fastened refastenable pant diapers.

In another form, a process may be adapted for assembling disposable pre-fastened pant diapers, each pant diaper comprising a chassis having a first waist region longitudinally

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opposed to a second waist region, and having a longitudinal axis and a lateral axis, the chassis comprising: a topsheet, a backsheet, and an absorbent core disposed between the topsheet and the backsheet, each pant diaper further comprising laterally opposed first side panels refastenably connected with the first waist region; and laterally opposed second side panels permanently connected with the second waist region and permanently connected with corresponding first side panels to form a waist opening. The process includes the steps of: advancing a first continuous web having a first surface and an opposing second surface in a machine direction wherein fastener components are connected with the first surface; cutting the first continuous web into first discrete patches, each first patch having a leading end region, a trailing end region, and a central region disposed between the leading and trailing end regions, wherein a first fastener is located in the leading end region and a second fastener is located in the trailing end region; advancing a second continuous web in the machine direction; cutting the second continuous web into second discrete patches, each second patch having a leading end region, a trailing end region, and a central region disposed between the leading and trailing end regions, advancing a third continuous web in the machine direction; cutting the third continuous web into discrete chasses, wherein each chassis advances such that the longitudinal axis is parallel with the machine direction; turning each chassis such that the lateral axis is parallel with the machine direction; refastenably connecting the first waist region of each chassis with a trailing end region of an advancing first patch and with a leading end region of a subsequently advancing first patch; permanently connecting the second waist region of each chassis with a trailing end region of an advancing second patch and with a leading end region of a subsequently advancing second patch; folding each chassis along the lateral axis to position the central region of each first patch into a facing relationship with the central region of each second patch; bonding a portion of the central region of each first patch with a portion of each second patch to create discrete bond regions; and cutting the first and second patches along the bond regions to create discrete pre-fastened refastenable pant diapers.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of a refastenable pant diaper in a pre-fastened configuration.

FIG. 2A is a partially cut away plan view of the diaper pant shown in FIG. 1.

FIG. 2B is a partially cut away plan view of a second embodiment of a diaper pant.

FIG. 3 is a schematic side view of a first converting apparatus adapted to manufacture pre-fastened, refastenable pant diapers.

FIG. 4 is a schematic side view of a second converting apparatus adapted to manufacture pre-fastened, refastenable pant diapers.

FIG. 5A is a view of a continuous length of chassis assemblies from FIGS. 3 and 4 taken along line A-A.

FIG. 5B1 is a view of a discrete chassis from FIGS. 3 and 4 taken along line B1-B1.

FIG. 5B2 is a view of a discrete chassis from FIGS. 3 and 4 taken along line B2-B2.

FIG. 5C is a view of a continuous length of advancing back side panel material from FIG. 3 taken along line C-C.

FIG. 5D is a view of a continuous length of front side panel material from FIGS. 3 and 4 taken along line D-D.

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FIG. 5E is a view of a discrete length of front side panel material from FIGS. 3 and 4 taken along line E-E.

FIG. 5F1 is a view of multiple discrete chassis spaced from each other along the machine direction MD connected with each other by the back side panel material and discrete lengths of front side panel material from FIG. 3 taken along line F1-F1.

FIG. 5F2 is a view of multiple discrete chassis spaced from each other along the machine direction MD connected with each other by the discrete lengths of back side panel material and discrete lengths of front side panel material from FIG. 4 taken along line F2-F2.

FIG. 5G is a view of the back side panel material bonded with a portion of the front side panel material from FIGS. 3 and 4 taken along line G-G.

FIG. 5H is a view of two discrete absorbent articles advancing the machine direction MD from FIGS. 3 and 4 taken along line H-H.

FIG. 5J is a view of a continuous length of advancing back side panel material from FIG. 4 taken along line J-J.

FIG. 5K is a view of a discrete length of advancing back side panel material from FIG. 4 taken along line K-K.

DETAILED DESCRIPTION OF THE INVENTION

The following term explanations may be useful in understanding the present disclosure:

“Absorbent article” is used herein to refer to consumer products whose primary function is to absorb and retain soils and wastes. “Diaper” is used herein to refer to an absorbent article generally worn by infants and incontinent persons about the lower torso. The term “disposable” is used herein to describe absorbent articles which generally are not intended to be laundered or otherwise restored or reused as an absorbent article (e.g., they are intended to be discarded after a single use and may also be configured to be recycled, composted or otherwise disposed of in an environmentally compatible manner).

The term “disposed” is used herein to mean that an element(s) is formed (joined and positioned) in a particular place or position as a macro-unitary structure with other elements or as a separate element joined to another element.

As used herein, the term “joined” encompasses configurations whereby an element is directly secured to another element by affixing the element directly to the other element, and configurations whereby an element is indirectly secured to another element by affixing the element to intermediate member(s) which in turn are affixed to the other element.

“Longitudinal” means a direction running substantially perpendicular from a waist edge to a longitudinally opposing waist edge of an absorbent article when the article is in a flat out, uncontracted state, or from a waist edge to the bottom of the crotch, i.e. the fold line, in a bi-folded article. Directions within 45 degrees of the longitudinal direction are considered to be “longitudinal.” “Lateral” refers to a direction running from a longitudinally extending side edge to a laterally opposing longitudinally extending side edge of an article and generally at a right angle to the longitudinal direction. Directions within 45 degrees of the lateral direction are considered to be “lateral.”

The term “substrate” is used herein to describe a material which is primarily two-dimensional (i.e. in an XY plane) and whose thickness (in a Z direction) is relatively small (i.e. 1/10 or less) in comparison to its length (in an X direction) and width (in a Y direction). Non-limiting examples of substrates include a web, layer or layers or fibrous materials, nonwovens, films and foils such as polymeric films or metallic foils.

These materials may be used alone or may comprise two or more layers laminated together. As such, a web is a substrate.

The term “nonwoven” refers herein to a material made from continuous (long) filaments (fibers) and/or discontinuous (short) filaments (fibers) by processes such as spunbonding, meltblowing, carding, and the like. Nonwovens do not have a woven or knitted filament pattern.

The term “machine direction” (MD) is used herein to refer to the direction of material flow through a process. In addition, relative placement and movement of material can be described as flowing in the machine direction through a process from upstream in the process to downstream in the process.

The term “cross direction” (CD) is used herein to refer to a direction that is generally perpendicular to the machine direction.

The term “pant” (also referred to as “training pant”, “pre-closed diaper”, “diaper-pant”, “pant diaper”, and “pull-on diaper”) refers herein to disposable absorbent articles having a continuous perimeter waist opening and continuous perimeter leg openings designed for infant or adult wearers. A pant can be configured with a continuous or closed waist opening and at least one continuous, closed, leg opening prior to the article being applied to the wearer. A pant can be preformed by various techniques including, but not limited to, joining together portions of the article using any refastenable and/or permanent closure member (e.g., seams, heat bonds, pressure welds, adhesives, cohesive bonds, mechanical fasteners, etc.). A pant can be preformed anywhere along the circumference of the article in the waist region (e.g., side fastened or seamed, front waist fastened or seamed, rear waist fastened or seamed). Example diaper pants in various configurations are disclosed in Japanese Patent Publication No. 1995080023A published Mar. 8, 1995.

“Pre-fastened” refers herein to pant diapers manufactured and provided to consumers in a configuration wherein the front waist region and the back waist region are fastened or connected to each other as packaged, prior to being applied to the wearer. As such pant diapers may have a continuous perimeter waist opening and continuous perimeter leg openings designed for infant or adult wearers. As discussed in more detail below, a diaper pant can be preformed by various techniques including, but not limited to, joining together portions of the diaper using refastenable and/or permanent closure members (e.g., seams, heat bonds, pressure welds, adhesives, cohesive bonds, mechanical fasteners, etc.). In addition, pant diapers can be preformed anywhere along the circumference of the waist region (e.g., side fastened or connected, front waist fastened or connected, rear waist fastened or connected).

The present disclosure relates to methods for manufacturing absorbent articles, and in particular, methods for making pre-fastened refastenable pant diapers. As discussed in more detail below, pre-fastened pant diapers may include a chassis having a first waist region and a longitudinally opposed second waist region. The chassis may also include a longitudinal axis and a lateral axis, wherein the longitudinal axis extends through the first and second waist regions. Each pant diaper may further include laterally opposed first side panels refastenable connected with the first waist region, and laterally opposed second side panels permanently connected with the second waist region and permanently connected with corresponding first side panels to form a waist opening. Aspects of the methods according to the present disclosure relate to the fabrication of refastenable pant diapers wherein discrete chassis are advanced in a machine direction such that the lateral axis is parallel with the machine direction. The discrete

chassis are also spaced apart from each other along the machine direction. First side panels are then refastenable connected with the first waist region, and second side panels are permanently connected the second waist regions of the discrete chassis. As discussed in more detail below, the methods disclosed herein connect chassis with discrete lengths of side panel material and/or connection zone material and eliminates the need for a removable sheet used in some manufacturing processes. This configuration forms a continuous web of articles formed by intermittently spaced chassis and intermittently spaced side panels bridging the gap between the intermittently spaced chassis. The forces imposed on the continuous web of absorbent articles during manufacture thereby extend through the front side panels and front waist region of the chassis and the back side panels and the back waist region of the chassis. The chassis are then folded in the cross direction parallel to a lateral centerline and the first and second side panels are subsequently bonded together. The article is then subjected to knife cut at or adjacent the bonded regions to create discrete, pre-fastened refastenable pant diapers.

The following provides a general description of various types of pant diapers that may be produced with the methods and apparatuses disclosed herein to help provide additional context to the subsequent discussion of the process embodiments.

FIGS. 1 and 2A show an example of a refastenable pant diaper **100** that may be constructed in accordance with the methods disclosed herein. In particular, FIG. 1 shows a perspective view of a refastenable pant diaper **100** in a pre-fastened configuration, and FIG. 2A shows a plan view of the pant diaper **100** with the portion of the diaper that faces away from a wearer oriented towards the viewer. The pant diaper **100** shown in FIGS. 1 and 2A includes a chassis **102**, first front ear panels **112a**, **112b**, and second back ear panels **114a**, **114b**.

With continued reference to FIG. 2A, the chassis **102** includes a first waist region **116**, a second waist region **118**, and a crotch region **120** disposed intermediate the first and second waist regions. The first waist region **116** may be configured as a front waist region, and the second waist region **118** may be configured as back waist region. In some embodiments, the length of each of the front waist region, back waist region, and crotch region may be $\frac{1}{3}$ of the length of the absorbent article **100**. The diaper **100** may also include a laterally extending front waist edge **120** in the front waist region **116** and a longitudinally opposing and laterally extending back waist edge **122** in the back waist region **118**. To provide a frame of reference for the present discussion, the diaper **100** and chassis **102** of FIG. 2A is shown with a longitudinal axis **124** and a lateral axis **126**. In some embodiments, the longitudinal axis **124** may extend through the front waist edge **120** and through the back waist edge **122**. And the lateral axis **126** may extend through a first longitudinal or right side edge **128** and through a midpoint of a second longitudinal or left side edge **130** of the chassis **102**.

As shown in FIGS. 1 and 2A, the pant diaper **100** may include an inner, body facing surface **132**, and an outer, garment facing surface **134**. The chassis **102** may include a backsheet **136** and a topsheet **138**. An absorbent assembly **140** including an absorbent core **142** may be disposed between a portion of the topsheet **138** and the backsheet **136**. As discussed in more detail below, the diaper **100** may also include other features, such as leg elastics and/or leg cuffs to enhance the fit around the legs of the wearer.

As shown in FIG. 2A, the periphery of the chassis **102** may be defined by the first longitudinal side edge **128**, a second

longitudinal side edge **130**; a first laterally extending end edge **144** disposed in the first waist region **116**; and a second laterally extending end edge **146** disposed in the second waist region **118**. Both side edges **128** and **130** extend longitudinally between the front waist edge **120** and the back waist edge **122**. The laterally extending end edges **144** and **146** of the chassis may form a portion of the laterally extending front waist edge **120** in the front waist region **116** and a portion of the longitudinally opposing and laterally extending back waist edge **122** in the back waist region **118**. When the pant diaper **100** is worn on the lower torso of a wearer, the front waist edge **120** and the back waist edge **122** of the chassis **102** may encircle a portion of the waist of the wearer. At the same time, the chassis side edges **128** and **130** may encircle at least a portion of the legs of the wearer. And the crotch region **120** may be generally positioned between the legs of the wearer with the absorbent core **142** extending from the front waist region **116** through the crotch region **120** to the back waist region **118**.

It is to also be appreciated that a portion or the whole of the diaper **100** may also be made laterally extensible. The additional extensibility may help allow the diaper **100** to conform to the body of a wearer during movement by the wearer. The additional extensibility may also help, for example, allow the user of the diaper **100** including a chassis **102** having a particular size before extension to extend the front waist region **116**, the back waist region **118**, or both waist regions of the diaper **100** and/or chassis **102** to provide additional body coverage for wearers of differing size, i.e., to tailor the diaper to an individual wearer. Such extension of the waist region or regions may give the absorbent article a generally hourglass shape, so long as the crotch region is extended to a relatively lesser degree than the waist region or regions, and may impart a tailored appearance to the article when it is worn.

As previously mentioned, the pant diaper **100** may include a backsheet **136**. The backsheet **136** may also define the outer surface **134** of the chassis **102**. The backsheet **136** may be impervious to fluids (e.g., menses, urine, and/or runny feces) and may be manufactured from a thin plastic film, although other flexible liquid impervious materials may also be used. The backsheet **136** may prevent the exudates absorbed and contained in the absorbent core from wetting articles which contact the diaper **100**, such as bedsheets, pajamas and undergarments. The backsheet **136** may also comprise a woven or nonwoven material, polymeric films such as thermoplastic films of polyethylene or polypropylene, and/or a multi-layer or composite materials comprising a film and a nonwoven material (e.g., having an inner film layer and an outer nonwoven layer). The backsheet may also comprise an elastomeric film. An example backsheet **140** may be a polyethylene film having a thickness of from about 0.012 mm (0.5 mils) to about 0.051 mm (2.0 mils). Exemplary polyethylene films are manufactured by Clopay Corporation of Cincinnati, Ohio, under the designation BR-120 and BR-121 and by Tredegar Film Products of Terre Haute, Ind., under the designation XP-39385. The backsheet **136** may also be embossed and/or matte-finished to provide a more clothlike appearance. Further, the backsheet **136** may permit vapors to escape from the absorbent core (i.e., the backsheet is breathable) while still preventing exudates from passing through the backsheet **136**. The size of the backsheet **136** may be dictated by the size of the absorbent core **142** and/or particular configuration or size of the diaper **100**.

Also described above, the pant diaper **100** may include a topsheet **138**. The topsheet **138** may also define all or part of the inner surface **132** of the chassis **102**. The topsheet **138** may be compliant, soft feeling, and non-irritating to the wear-

er's skin. It may be elastically stretchable in one or two directions. Further, the topsheet **138** may be liquid pervious, permitting liquids (e.g., menses, urine, and/or runny feces) to penetrate through its thickness. A topsheet **138** may be manufactured from a wide range of materials such as woven and nonwoven materials; apertured or hydroformed thermoplastic films; apertured nonwovens, porous foams; reticulated foams; reticulated thermoplastic films; and thermoplastic scrims. Woven and nonwoven materials may comprise natural fibers such as wood or cotton fibers; synthetic fibers such as polyester, polypropylene, or polyethylene fibers; or combinations thereof. If the topsheet **138** includes fibers, the fibers may be spunbond, carded, wet-laid, meltblown, hydroentangled, or otherwise processed as is known in the art.

Topsheets **138** may be selected from high loft nonwoven topsheets, apertured film topsheets and apertured nonwoven topsheets. Apertured film topsheets may be pervious to bodily exudates, yet substantially non-absorbent, and have a reduced tendency to allow fluids to pass back through and rewet the wearer's skin. Exemplary apertured films may include those described in U.S. Pat. Nos. 5,628,097; 5,916,661; 6,545,197; and 6,107,539.

As mentioned above, the pant diaper **100** may also include an absorbent assembly **140** that is joined to the chassis **102**. As shown in FIG. 2A, the absorbent assembly **140** may have a laterally extending front edge **148** in the front waist region **116** and may have a longitudinally opposing and laterally extending back edge **150** in the back waist region **118**. The absorbent assembly may have a longitudinally extending right side edge **152** and may have a laterally opposing and longitudinally extending left side edge **154**, both absorbent assembly side edges **152** and **154** may extend longitudinally between the front edge **148** and the back edge **150**. The absorbent assembly **140** may additionally include one or more absorbent cores **142** or absorbent core layers. The absorbent core **142** may be at least partially disposed between the topsheet **138** and the backsheet **136** and may be formed in various sizes and shapes that are compatible with the diaper **100**. Exemplary absorbent structures for use as the absorbent core of the present disclosure are described in U.S. Pat. Nos. 4,610,678; 4,673,402; 4,888,231; and 4,834,735.

Some absorbent core embodiments may comprise fluid storage cores that contain reduced amounts of cellulosic air-felt material. For instance, such cores may comprise less than about 40%, 30%, 20%, 10%, 5%, or even 1% of cellulosic air-felt material. Such a core may comprise primarily absorbent gelling material in amounts of at least about 60%, 70%, 80%, 85%, 90%, 95%, or even about 100%, where the remainder of the core comprises a microfiber glue (if applicable). Such cores, microfiber glues, and absorbent gelling materials are described in U.S. Pat. Nos. 5,599,335; 5,562,646; 5,669,894; and 6,790,798 as well as U.S. Patent Publication Nos. 2004/0158212 and 2004/0097895.

As previously mentioned, the diapers **100** may also include elasticized leg cuffs **156**. It is to be appreciated that the leg cuffs **156** can be and are sometimes also referred to as leg bands, side flaps, barrier cuffs, elastic cuffs or gasketing cuffs. The elasticized leg cuffs **156** may be configured in various ways to help reduce the leakage of body exudates in the leg regions. Example leg cuffs **156** may include those described in U.S. Pat. Nos. 3,860,003; 4,909,803; 4,695,278; 4,795,454; 4,704,115; 4,909,803; and U.S. Patent Publication No. 20090312730A1.

As mentioned above, pant diapers may be manufactured and provided to consumers in a configuration wherein the front waist region and the back waist region are pre-fastened or connected to each other as packaged, prior to being applied

to the wearer. For example, the pant diaper **100** may be folded about a lateral centerline with the interior surface **132** of the first waist region **116** in surface to surface contact with the interior surface **132** of the second waist region **118**. As such, pant diapers may have a continuous perimeter waist opening and continuous perimeter leg openings designed for infant or adult wearers. As discussed in more detail below, a diaper pant can be preformed by various techniques including, but not limited to, joining together portions of the diaper using refastenable and/or permanent closure members (e.g., seams, heat bonds, pressure welds, adhesives, cohesive bonds, mechanical fasteners, etc.). In addition, pant diapers can be preformed anywhere along the circumference of the waist region (e.g., side fastened or connected, front waist fastened or connected, rear waist fastened or connected).

As previously mentioned, pant diapers may be configured with side panels connected with the chassis in one or both of the waist regions. For example, the pant diaper **100** shown in FIGS. 1 and 2A includes first side panels **112a**, **112b** connected with second side panels **114a**, **114b**, respectively. The first side panels **112a**, **112b** are refastenably connected with the chassis **102** in the first waist region **116** and extend laterally outward from the side edges **128**, **130** of the chassis. The second side panels **114a**, **114b** are permanently connected with the chassis **102** in the second waist region **118** and extend laterally outward from the side edges **128**, **130** of the chassis. As shown in FIG. 2A, the second side panels **114a**, **114b** are defined by opposing end regions of a continuous belt **114** that is permanently connected with the chassis **102** along the second waist region **118**. The first side panel **112a** is connected with the second side panel **114a**, and the first side panel **112b** is connected with the second side panel **114b**. The first side panels **112a**, **112b** each include proximal regions **174a** refastenably connected with the first waist region **116** of the chassis **102**. And second ear panels **114a**, **114b** each include proximal regions **174b** defined by the continuous belt **114** permanently connected with the second waist region **118** of the chassis **102**. With reference to FIGS. 1 and 2A, a distal region **176a** of the first side panel **112a** and a distal region **176b** of the second side panel **114a** may be connected with each other along a first side seam **178**. And a distal region **176a** of the first side panel **112b** and a distal region **176b** of the second side panel **114b** may be connected with each other along a second side seam **180**.

It is to be appreciated that the second side panels may be configured in different ways other than as depicted in FIG. 2A. For example, FIG. 2B shows a plan view of a pant diaper **100** having the same components as described above with reference to FIG. 2A, except the second side panels **114a**, **114b** shown in FIG. 2B are not defined by opposing end regions of a continuous belt **114**. Instead, the second side panels **114a**, **114b** shown in FIG. 2B are defined by two separate and discrete pieces of material connected with the second waist region **118** of the chassis **102**. In particular, the second ear panels **114a**, **114b** each include proximal regions **174b** permanently connected with the second waist region **118** of the chassis **102**.

The side panels **112a**, **112b** and **114a**, **114b** may be substantially rectangular in shape or the side panels may be shaped in such a way as to provide an integral tab for ease of opening and refastening. The side panels may also be extensible in at least the lateral direction. The side panels may also be elastically extensible in the lateral direction. Furthermore, the side panels may be elastically extensible in both the longitudinal and lateral directions. The side panels may comprise a film, a nonwoven or a combination of film and nonwoven. The side panels may also comprise a plurality of strand-like

filaments and a nonwoven. The strand-like elements may also be elastically extensible in at least the lateral direction.

It is to be appreciated that the side panels may include various types of materials, such as disclosed with respect to the elastic belts described in U.S. Pat. No. 7,569,039, which is hereby incorporated by reference herein. For example, the side panels may include plastic films; apertured plastic films; nonwoven or nonwoven webs of natural materials (e.g., wood or cotton fibers); synthetic fibers (e.g. polyolefins, polyamides, polyester, polyethylene, and/or polypropylene fibers); or combinations of natural and/or synthetic fibers; or coated woven or nonwoven webs. In some embodiment, the side panels may include a stretchable nonwoven. In other embodiments, the side panels may include an inner hydrophobic non-stretchable nonwoven material and an outer hydrophobic, non-stretchable nonwoven material. In addition, the side panels may include waist elastic material and side elastic material including one or more of elastic elements such as strand or panels extending in a transverse direction. The side panel elastic material may also be interposed between an outer layer and inner layer.

The ability to refasten an initially pre-fastened pant diaper may offer convenience to the caregiver. In some instances, it may be more convenient to apply the absorbent article like a traditional tape style diaper when away from home or when it is inconvenient to remove the clothing and/or shoes. Because it is difficult to predict when a change will be necessary and therefore when a particular mode of application will be needed, it is beneficial to have a disposable pant diaper that is adaptable to being applied either as a traditional tape style diaper or as a disposable pant diaper, pull-on. In addition, an absorbent article that can be applied like a traditional tape style diaper or a disposable pant diaper also permits inspection of the interior of the product without having to pull the product down. These refastenable structures may also provide dual functionality enabling the wrapping and disposal of the used product.

It is to be appreciated that the proximal regions of the side panels may be connected with the chassis in various ways, and the distal regions of the ear panels may be connected with each other in various ways. For example, the proximal regions and/or distal regions of the side panels disposed in one or both of the waist regions may be permanently bonded, releasably connected, and/or refastenably connected with the chassis and/or each other, with for example, adhesives, cohesive, thermal bonding, ultrasonic bonding, mechanical bonding and mechanical fastening e.g. hook and loop type fasteners. For example, one or more fastener elements may be located on the side panels and may be adapted to refastenably connect with one or more corresponding fastening elements located in the first or second waist regions or alternatively the fastener elements may be adapted to refastenably connect with one or more components of the absorbent article including the side panels. The diaper pants can also include other features such as elastically extensible side panels that may each include one or more pieces of material.

It should also be appreciated that the side panels in one waist region may have the same lateral extent from the side edge of the chassis to the distal edge of the side panel as the longitudinally opposed side panels in the opposite waist region or alternatively the side panels disposed in a first waist region may have different lateral extent as measured from the side edge of the chassis to the distal edge of the side panel than the side panels disposed in a second waist region.

As previously mentioned, the bonds of the side edge seams **178** and **180** may be permanent and can be formed in various ways appropriate for the specific materials employed. Thus,

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example bond types may include discrete bonds such as sonic sealed bonds, heat sealed bonds, high pressure bonds, radio frequency bonds, adhesive or cohesive bonds, sewed bonds, autogeneous bonds, and combinations thereof. In accordance with one aspect of the disclosure, the permanent side edge seams **178** and **180** may be joined by a predetermined pattern of heat/pressure or ultrasonic welds which withstands the forces and stresses exacted onto the side edge seam during application and wear of the pant. The permanent side edge seams **178**, **180** may be formed as disclosed in U.S. Pat. Nos. 5,779,831; 5,772,825; 5,607,537; 5,622,589; 5,662,638; 6,042,673; and 6,726,792.

As mentioned above, the first side panels **112a**, **112b** may be refastenably connected with the first waist region **116** of the chassis **102**. As such, the first side panels **112a**, **112b** may be configured to include fastening components **162**, such as shown in FIG. 2A. The fastening components **162** may form a portion of or may be permanently bonded, adhered or otherwise joined directly or indirectly to the first side panels **112a**, **112b** at or adjacent the proximal edge regions **174a** of the first side panels **112a**, **112b**. In some embodiments, the fastening components **162** may be permanently bonded to the first side panels **112a**, **112b** in various ways, such as for example, by adhesive bonds, sonic bonds, pressure bonds, thermal bonds or combinations thereof.

The fastening components **162** are adapted to refastenably connect with the first waist region **116** of the chassis **102**. As such, the fastening components **162** may include various types of refastenably engageable fasteners and various types of refastenable fastening structures. For example, the fastening components **162** may include mechanical fasteners, **166**, in the form of hook and loop fasteners, hook and hook fasteners, macrofasteners, buttons, snaps, tab and slot fasteners, tape fasteners, adhesive fasteners, cohesive fasteners, magnetic fasteners, hermaphroditic fasteners, and the like. Some examples of fastening systems and/or fastening components **162**, **164** are discussed in U.S. Pat. Nos. 3,848,594; 4,662,875; 4,846,815; 4,894,060; 4,946,527; 5,151,092; 5,221,274; 6,251,097; 6,669,618; 6,432,098; and U.S. Patent Publication Nos. 2007/0078427 and 2007/0093769.

As previously mentioned, the fastening components **162** may be adapted to refastenably engage or connect with another portion of the diaper **100**. For example, as shown in FIG. 2A, the diaper **100** may include a connection zone **168**, sometimes referred to as a landing zone, in the first waist region **116**. As such, when the taped diaper **100** is placed on a wearer, the fasteners **162** are refastenably connected with the connection zone **168** in the first waist region **116** to form a closed waist circumference and a pair of laterally opposing leg openings. It is to be appreciated that the connection zone **162** may be constructed from a separate substrate that is connected with the chassis **102** of the taped diaper. In some embodiments, the connection zone may be integrally formed as part of the backsheet **136** of the diaper **100** or may be formed as part of the first and second ears in one or both of the waist regions, such as described in U.S. Pat. Nos. 5,735,840 and 5,928,212.

As previously mentioned, the apparatuses and methods according to the present disclosure may be utilized to assemble various components of pre-fastened, refastenable pant diapers **100**. For example, FIG. 3 shows a schematic view of a converting apparatus **300** adapted to manufacture pant diapers **100**. The method of operation of the converting apparatus **300** may be described with reference to the various components of pant diapers **100** described above and shown in FIGS. 1 and 2A.

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As described in more detail below, the converting apparatus **300** shown in FIG. 3 operates to advance discrete chassis **102** along a machine direction MD such that the lateral axis of each chassis **102** is parallel with the machine direction, and wherein the chassis **102** are spaced apart from each other along the machine direction. In addition, the apparatus **300** refastenably connects the front side panels **112a**, **112b** with first waist regions **116** of advancing chassis **102** and permanently connects the back side panels **114a**, **114b** with the back waist regions **118** of advancing chassis **102**.

As shown in FIGS. 3 and 5A, a continuous length of chassis assemblies **302** are advanced in a machine direction MD to a carrier apparatus **308** and cut into discrete chassis **102** with knife roll **306**. The continuous length of chassis assemblies may include absorbent assemblies **140** sandwiched between topsheet material **138** and backsheet material **136**, leg elastics, barrier leg cuffs and the like. A portion of the chassis assembly is cut-away to show a portion of the topsheet material **138** and an absorbent assembly **140**. The continuous length of chassis assemblies **302** may also include connection zones **168** connected with the backsheet material **136** and spaced apart from each other along the machine direction MD.

After the discrete absorbent chassis **102** are cut by the knife roll **306**, the carrier apparatus **308** rotates and advances the discrete chassis **102** in the machine direction MD in the orientation shown in FIG. 5B1, wherein the longitudinal axis **124** of the chassis **102** is generally parallel with the machine direction MD. While the chassis **102** shown in FIG. 5B1 is shown with the first laterally extending end edge **144** as a leading edge and the second laterally extending end edge **146** as the trailing edge, it is to be appreciated that in other embodiments, the chassis **102** may be advanced in other orientations. For example, the chassis may be oriented such that the first laterally extending end edge **144** is a trailing edge and the second laterally extending end edge **146** is a leading edge. The carrier apparatus **308** also rotates while at the same time changing the orientation of the advancing chassis **102**. The carrier apparatus **308** may also change the speed at which the chassis **102** advances in the machine direction MD. It is to be appreciated that various forms of carrier apparatuses may be used with the methods herein, such as for example, the carrier apparatuses disclosed in U.S. Pat. No. 7,587,966. FIG. 5B2 shows the orientation of the chassis **102** on the carrier apparatus **308** while advancing in the machine direction. More particularly, FIG. 5B2 shows the chassis **102** with the lateral axis **126** of the chassis **102** generally parallel with the machine direction MD, and wherein the first longitudinal side edge **128** as the trailing edge and the second longitudinal side edge **130** as the leading edge.

As discussed below with reference to FIGS. 3, 5C, 5D, 5E, 5F1, 5G, and 5H, the chassis **102** are transferred from the carrier apparatus **308** and combined with materials that form first side panels **112a**, **112b** and second side panels **114a**, **114b**.

With reference to FIGS. 3 and 5C, the chassis **102** are transferred from the carrier apparatus **308** to a nip **316** between the carrier apparatus **308** and a carrier apparatus **318** where the chassis **102** is combined with a continuous length of advancing back side panel material **310**. The back side panel material **310** defines a wearer facing surface **312** and an opposing garment facing surface **314**. And the wear facing surface **312** of the back side panel material **310** may be combined with the garment facing surface **134** of the chassis **102** along the second waist region **116**. As shown in FIG. 3, adhesive **320** may be intermittently applied to the wearer

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facing surface **312** before combining the back side panel material **310** with the discrete chassis **102**.

As shown in FIGS. **3**, **5D**, and **5E**, a continuous length of front side panel material **322** advances in a machine direction MD to carrier apparatus **318**, where a knife roll **324** cuts the continuous length of front side panel material **322** into discrete lengths of front side panel material **322a**. As shown in FIG. **3**, the discrete lengths of front panel material **322a** are spaced from each other in the machine direction by the carrier apparatus **318**. An example carrier apparatus **318** for achieving the spacing between discrete components is disclosed in disclosed in U.S. Pat. No. 7,587,966.

With continued reference to FIGS. **3** and **5D**, the front side panel material **322** also defines a wearer facing surface **326** and an opposing garment facing surface **328**. And fastening components **162** are intermittently spaced along the machine direction MD on the wearer facing surface **326** of the front side panel material **322**. As shown in FIG. **5D**, the fastening components **162** are arranged in pairs **330** of fastening components **162** in close proximity to each other, and the pairs **330** are spaced apart from other pairs **330** along the machine direction MD. With reference to FIGS. **3** and **5E**, the knife **324** cuts the front side panel material **322** at locations between the two fastening components **162** of each pair **330**, thus creating discrete lengths or patches of front side panel material **322a**. As shown in FIG. **5E**, fastening components **162** are located in opposing end portions each discrete length or patch of front side panel material **322a**. As such, the discrete length of front side panel material **322a** includes a leading end fastening component **162'** and a trailing end fastening component **162''**. As shown in FIG. **3**, the anvil roll **318** advances the discrete lengths of front side panel material **322a** to the nip **316**, where each discrete length of front side panel material **322a** is connected with two chassis **102**. More particularly, the leading end fastening component **162'** is refastenably connected with the connection zone **168** in the first waist region **116** of a chassis **102** being transferred from the carrier apparatus **308** at the nip **316**. And the trailing end fastening component **162''** is refastenably connected with the connection zone **168** of a chassis **102** subsequently transferred from the carrier apparatus **308** at the nip **316**. As such, opposing end portions of each discrete length of front side panel material **322a** are refastenably connected with two chassis **102** traveling in the machine direction, such as shown in FIG. **5F1**.

With reference to FIGS. **3** and **5F1**, multiple discrete chassis **102** spaced from each other along the machine direction MD are connected with each other by the back side panel material **310** and discrete lengths of front side panel material **322a**. And the chassis **102** are advanced from the nip **316** to a folder **332**. Various folder embodiments may be used, such as for example disclosed in U.S. Pat. No. 6,913,664, which is incorporated by reference herein. At the folder **332**, each chassis **102** is folded in the cross direction CD along a lateral axis **126** to place the first waist region **116**, and specifically, the inner, body facing surface **132** into a facing, surface to surface orientation with the inner, body surface **132** of the second waist region **118**. The folding of the chassis also positions the wearer facing surface **312** of the back side panel material **310** extending between each chassis **102** in a facing relationship with the wearer facing surface **326** of the front side panel material **322a** extending between each chassis **102**. As shown in FIGS. **3** and **5G**, the discrete chassis **102** connected with the back side panel material **310** and discrete lengths of front side panel material **322a** are advanced from the folder **332** to a bonder **334**. The bonder **334** operates to bond a portion of the back side panel material **310** extending between each chassis **102** with a portion of the front side

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panel material **322a** extending between each chassis **102**, thus creating discrete bond regions **336**. It is to be appreciated that various types of bonders can be used to bond the back side panel material **310** with the front side panel material **322a**, such as for example disclosed in U.S. Pat. Nos. 7,383,865 and 6,546,987, which are incorporated by reference herein.

As shown in FIGS. **3** and **5H**, the discrete chassis **102** connected with the continuous back side panel material **310** and discrete lengths of front side panel material **322a** are advanced from the bonder **334** to a knife roll **338** where the discrete bond regions **336** are cut into along the cross direction to create a first side seam **178** on an absorbent article **100** and a second side seam **180** on a subsequently advancing absorbent article.

FIG. **4** shows a schematic view of a second embodiment of a converting apparatus **300'** adapted to manufacture pant diapers **100**, such as shown in FIG. **2B**. As discussed in more detail below, the method of operation of the converting apparatus **300'** differs from the converting apparatus described above with respect to FIG. **3** with respect to the connection of two separate and discrete second ear panels **114a**, **114b** with the second waist region **118** of the chassis **102**. Other aspects of the assembly process shown in FIG. **4** are the same as described above with reference to FIGS. **3**, **5A**, **5B1**, **5B2**, **5D**, **5E**, **5G**, and **5H**.

With reference to FIGS. **4** and **5J**, a continuous length of back side panel material **310** defining a wearer facing surface **312** and an opposing garment facing surface **314** advances in a machine direction MD to a carrier apparatus **340**. At carrier apparatus **340**, a knife roll **342** cuts the continuous length of back side panel material **310** into discrete lengths of back side panel material **310a**. As shown in FIG. **5K**, each discrete length of back side panel material **310a** includes a leading end portion **344a** and a trailing end portion **344b**. As shown in FIG. **3**, the discrete lengths of back panel material **310a** are spaced from each other in the machine direction by the carrier apparatus **340**. An example carrier apparatus **340** for achieving the spacing between discrete components is disclosed in U.S. Pat. No. 7,587,966. As shown in FIG. **3**, adhesive **346** may be intermittently applied to the wearer facing surface **312** before combining the back side panel material **310a** with the discrete chassis **102**.

After applying adhesive, the wearer facing surface **312** of the back side panel material **310a** may be connected with the garment facing surface **134** of the chassis **102** along the second waist region **116** at nip **316**. More particularly, each discrete length of back side panel material **310a** is connected with two chassis **102**, wherein the leading end portion **346a** is bonded with the second waist region **116** of a chassis **102** being transferred from the carrier apparatus **308** at the nip **316** and the trailing end portion **346b** is bonded with the second waist region of another chassis **102** subsequently transferred from the carrier apparatus **308** at the nip **316**. As such, opposing end portions of each discrete length of back side panel material **310a** are bonded with two chassis **102** traveling in the machine direction, such as shown in FIG. **5F2**. And the leading end portions **344a** and the trailing end portions **344b** of the back side panel material **310a** correspond with the proximal regions **174b** the second ear panels **114a**, **114b** discussed above with reference to FIG. **2B**. From the nip **316**, the discrete chassis connected with each other by the discrete lengths of back side panel material **310a** and discrete lengths of front side panel material **322a** are advanced from the nip **316** to folder **332**, bonder **334**, and knife roll **338** as discussed above with reference to FIGS. **5F1**, **5G**, and **5H**.

Although the processes and apparatuses have been described in the context of assembling absorbent articles

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having side panels refastenably connected with the first waist region, it is to be appreciated that the processes and apparatuses described above can be configured to assemble absorbent articles having various other configurations. For example, the above described processes and apparatuses can be configured to assemble absorbent articles with side panels refastenably connected with the second waist region. In another example, the above described processes and apparatuses can be configured to assemble absorbent articles with four side panels refastenably connected to both the first and second waist regions, and wherein the corresponding side panels are bonded together along side seams.

The dimensions and values disclosed herein are not to be understood as being strictly limited to the exact numerical values recited. Instead, unless otherwise specified, each such dimension is intended to mean both the recited value and a functionally equivalent range surrounding that value. For example, a dimension disclosed as "40 mm" is intended to mean "about 40 mm."

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While particular embodiments of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

What is claimed is:

1. A process for assembling disposable pre-fastened pant diapers, each pant diaper comprising a chassis having a first waist region longitudinally opposed to a second waist region, and having a longitudinal axis and a lateral axis, the chassis comprising: a topsheet, a backsheet, and an absorbent core disposed between the topsheet and the backsheet, each pant diaper further comprising laterally opposed first side panels refastenably connected with the first waist region; and laterally opposed second side panels permanently connected with the second waist region and permanently connected with corresponding first side panels to form a waist opening, the process comprising the steps of:

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advancing a first continuous web having a first surface and an opposing second surface in a machine direction wherein fastener components are connected with the first surface;

cutting the first continuous web into first discrete patches, each first patch having a leading end region, a trailing end region, and a central region disposed between the leading and trailing end regions, wherein a first fastener is located in the leading end region and a second fastener is located in the trailing end region;

advancing a second continuous web in the machine direction;

cutting the second continuous web into second discrete patches, each second patch having a leading end region, a trailing end region, and a central region disposed between the leading and trailing end regions,

advancing a third continuous web in the machine direction; cutting the third continuous web into discrete chassis, wherein each chassis advances such that the longitudinal axis is parallel with the machine direction;

turning each chassis such that the lateral axis is parallel with the machine direction;

refastenably connecting the first waist region of each chassis with a trailing end region of an advancing first patch and with a leading end region of a subsequently advancing first patch;

permanently connecting the second waist region of each chassis with a trailing end region of an advancing second patch and with a leading end region of a subsequently advancing second patch;

folding each chassis along the lateral axis to position the central region of each first patch into a facing relationship with the central region of each second patch;

bonding a portion of the central region of each first patch with a portion of each second patch to create discrete bond regions; and

cutting the first and second patches along the bond regions to create discrete pre-fastened refastenable pant diapers.

2. The process of claim 1, wherein the first waist region is a front waist region.

3. The process of claim 1, wherein the second waist region is a back waist region.

4. The process of claim 1, wherein the first continuous web comprises a continuous length of front side panel material.

5. The process of claim 1, wherein the first patches comprise discrete lengths of front side panel material.

6. The process of claim 1, wherein the second continuous web comprises a continuous length of back side panel material.

7. The process of claim 1, wherein the second patches comprise discrete lengths of back side panel material.

8. The process of claim 1, wherein the third continuous web comprises a continuous length of chassis assemblies.

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